

SPLIT

Work Order ID 54852 -1

December 30, 2009 7:49:21 AM



Page 1

Item ID: D350-588-011

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/30/09 Start Qty: 10.00

Required Date: 12/31/09 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-588-011 C11G002

8 10/01/09

10-1-4 BG 10/01/04

110



Packaging

Packaging

Pick Kit

Memo

QC4- 100% Inspect kits for completeness

Memo

120



QC

Quality Control

8 10/01/09

10-1-4

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Item ID: D350-588-011

Accept



Revision ID:

Setup Start



Item Name: Aft Door Fwd Hinge Modification

Stop



Start Date: 12/30/09 Start Qty: 10.00

Required Date: 12/31/09 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D350-588-011

Location: 28

PPP Rev: 2

10-1-19 425

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/20 10

MF 10-1-19

Picklist Print

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Page 1

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No			120	Each	136.0000	20.0000			
Screw												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

136

104394

3

113064

100

113096

33

120

Each

84.0000

80.0000

AN526C832R8

Purchased

No

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

84

108335

1

111900

83

10-1-4
M113595 \$
10-1-8- sl

75

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Page 2

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R9		Purchased	No			120	Each	145.0000	80.0000			

AN526C832R9

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

145

107376

51

108377

5

108928

14

110372

8

110915

1

111916

1

112492

65

10-1-4
M113595

26x
10-1-8

SP

54

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 Washer		Purchased	No			120	Each	1,444.000	40.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	1444
105442	8
109059	2
109840	23
110139	2
110985	202
111279	5
111668	48
112314	132
112369	22
113149	1000

10-1-11 5/ 105

195

40

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 Washer		Purchased	No			120	Each	1,047.000	240.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1047
107091	9
108335	11
110382	48
110917	3
111578	60
112314	196
112385	720

Manufactured No 120 Each 29.0000 10.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	29
37739	29

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2144  Hinge Bracket		Manufactured	No			120	Each	14.0000	10.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

14

41174

14

Manufactured No

120

Each

16.0000

20.0000



16-1-4

SP

D2150



Packer Doubler, Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

45813

16

Manufactured No

120

Each

60.0000

20.0000



16-1-4

B55016
10-1-19 SP

SP

D2151



Packer Doubler, Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

51407

60

14

10-1-4

100

SP

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2153 Door Prop		Manufactured	No			120	Each	32.0000	10.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

48373

32

Manufactured No

120

Each

29.0000

10.0000

10

10-1-4

sf

10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

44890

19

45814

10

1

9

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237 <i>+2</i>  Striker Plate		Manufactured	No			120	Each	64.0000	20.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

9

46162

9

Main Warehouse

ST022

55

52327

55

Manufactured No

120

f

170.7040

76.3158

D2461 *+1*



Neoprene "D" Seal

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

170.7039842

34304

14.234

39782

156.469984

cut 1 X 87.00"

maxed Sidelay

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
12463  Seal		Manufactured	No			120	f	569.9926	76.3158		10-1-4	sf

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

75.3752

31350

1.8278

34305

18.25

41121

3.75

43841

51.5474

Main Warehouse

ST404

494.6173684

50075

494.617368

Manufactured No

120

Each

36.0000

20.0000



10-1-4

sf 10x

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

36

36043

2

48648

2

53889

32

20

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification



Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2585  Mounting Channel		Manufactured	No			120	Each	90.0000	20.0000 		10-1-46 sf	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 64

45888 4

53798 60

Main Warehouse

ST37 26

51526 26

Manufactured No 120 Each 89.0000 20.0000

D2586

Door Latch

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 89

45554 1

47183 2

50213 86

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification



Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2587 +1  Door Slug, 350 Hinge		Manufactured	No			120	Each	48.0000	10.0000	 10-1-4		sf

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	48	
48647	48	

D2589 +1  Keys, Key Chain, 350 Hinge		Manufactured	No			120	Each	56.0000	10.0000	 10-1-4		sf
---	--	--------------	----	--	--	-----	------	---------	---------	--	--	----

Warehouse	Loc Qty	Loc Code
Location		
HONG KONG		
ST	1	
46840	15	
46846	1	
50378	40	

D2690-17 +1  Cable		Manufactured	No			120	Each	18.0000	10.0000	 10-1-4		sf
---	--	--------------	----	--	--	-----	------	---------	---------	--	--	----

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST41	18	
50666	18	

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-1  Hinge Bracket		Manufactured	No			120	Each	29.0000	10.0000			

10-1-4

sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

41166

7

45788

4

50235

6

53464

12

120

Each

25.0000

10.0000

10-1-4

sf

10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

25

45797

13

53465

12

10

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2858-1



Hinge Bracket

Manufactured

No

120

Each

27.0000

10.0000



10-1-4

sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

43364

3

45798

24

120

Each

19.0000

10.0000



10-1-4

sf

D2858-2



Hinge Bracket

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

41439

4

45799

15

120

sf

855.0000

10.0000



10-1-4

sf

10

PG-778150-550-ROI.



7781 9oz Glass 50"x125yd

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

855

111166

855

10

1- cut 1 square ft of glass cloth

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-4 RIVET		Purchased	No			120	Each	7,765.000	120.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7765	
104374	3765	
110398	4000	

MS20470AD4-5 Rivet, Universal Head		Purchased	No			120	Each	2,477.000	180.0000			
---------------------------------------	--	-----------	----	--	--	-----	------	-----------	----------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2477	
111916	2477	

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08 Nut	x18	Purchased	No			120	Each	317.0000	180.0000			

Warehouse	Loc Qty	Loc Code
Main Warehouse		
ST	317	

110002	24
111889	30
112243	43
112492	24
112612	1
112794	7
113226	188

M113595 6x
10-1-8 sf

MS21042L3



Nut

Purchased

No

120 Each

3,314.000 40.0000

Warehouse	Loc Qty	Loc Code
Main Warehouse		
ST	3314	

110844	35
111274	27
111668	64
112314	1688
112385	500
113523	300
113537	700

40

10x

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Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-08-11		Purchased	No			120	Each	76.0000	20.0000			
Screw												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

76

111977

76

120

Each

163.0000

20.0000

20

10-1-4

Svd

Sf

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

163

106903

3

108169

4

109321

4

111916

52

112794

100

20

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52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries